

Work Order ID 163226***163226***

Page 1

Monday, June 26, 2017 1:34:07 PM

Item ID: D4617-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Emergency Escape Ladder

Start Date: 6/26/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/7/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4617

C

100

0.00

100

CNC Bend 1

CNC Delta 100 Bender

Memo

0.23

BEND RAIL AS PER DWG AND TO FIT PROFIL OF WELDING JIG DT9803
(ON LENGTH OF TUBE, 20 FEET MAKES 2 RAILL)***BENDER SET UP SAME AS BASKET RIB, TOWERS ON NARROW,
RAM AT 2000 PTS FOR BENDING RADIUS***

110

Weld per dwg A/R 4130 rod Batch:

0.00

110

Large Fab

Large Fab

Memo

1.91

1- CUT STEPS AS PER DWG AND PREP FOR WELDING

2- CUT RAIL

3- INSTALL PARTS ON WELDING JIG DT9803 AND WELD AS PER DWG

N/A
done on 147369
see attached

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Item ID: D4617-041

Accept

N900040100Setup Start ***NS1***

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Stop ***NS2***

Item Name: Emergency Escape Ladder

Start Date: 6/26/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/7/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				_____	_____	_____	_____
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.02				_____	_____	_____	_____
140 *140* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.79				_____	_____	_____	_____

see
147369

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Item ID: D4617-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Emergency Escape Ladder
Start Date: 6/26/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/7/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	Fire Red(Ref:4.3.5.10) per QSI005 4.3 Memo START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.42				_____	_____	_____	_____
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01				_____	_____	_____	_____
170 *170* Small Fab Small Fab	1- Assemble clamps, clamps cover and tube caps to ladder as per dwg 2- Install decals as per dwg	0.00 0.56				_____	_____	_____	_____

Handwritten notes: *see 147309*

Stamp: DAS 30 9-89 JUN 28 2017

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Item ID: D4617-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Emergency Escape Ladder
Start Date: 6/26/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/7/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.02				1			DAS 38 9-89 JUN 28 2017
190 *190* Packaging Packaging	Identify as per dwg & Stock Location PKG Memo	0.00 0.01				/			JUL 0 5 2017 DAS 6 9-89
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.10							17/7/5 df DAS 21 9-89 JUL 0 5 2017

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Work Order ID: 163226

163226

Parent Item: D4617-041

D4617-041

Parent Item Name: Emergency Escape Ladder

Start Date: 6/26/2017

Required Date: 7/7/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.04.12 NEW ISSUE DD VERF:EC
16.08.26 AS PER DWG REV.PC1 DD VERF:JFS

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NT0.750W.035		Purchased	No			100	f	102.6330	20	21.05263			
M4130NT0 750W 035													
4130 RD TUBE .750 X .035W													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT032				47.833					
				m135250				47.833					
				MAT033				54.8					
				121910				18.8					
				m135250				36					
M4130NT0.750W.035		Purchased	No			110	f	102.6330	5.06	5.326316			
M4130NT0 750W 035													
4130 RD TUBE .750 X .035W													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT032				47.833					
				m135250				47.833					
				MAT033				54.8					
				121910				18.8					
				m135250				36					
D4617-045		Manufactured	No			170	Each	18.0000	2	2			
D4617-045													
Clamp Assembly													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				st113				4					
				148150				4					
				ST116A				14					
				156543				14					

N/A

done on 6/26/17

470147369

17-06-26

2

Picklist Print

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Work Order ID: 163226

163226

Parent Item: D4617-041

D4617-041

Parent Item Name: Emergency Escape Ladder

Start Date: 6/26/2017

Required Date: 7/7/2017

Start Qty: 1.00

Required Qty: 1.00

D4617-049

Manufactured No

170

Each

10.0000

2

2

D4617-049

Clamp Assembly

Location

Loc Qty

Loc Code

FG

2

150561

2

ST112

8

152014

8

D4618-041

Manufactured No

170

Each

18.0000

2

2

D4618-041

Clamp Assembly Cover

Location

Loc Qty

Loc Code

st113

4

139782

4

ST116A

14

156542

14

D4618-043

Manufactured No

170

Each

6.0000

2

2

D4618-043

Clamp Assembly Cover

Location

Loc Qty

Loc Code

st113

6

152017

6

D4621-1

Manufactured No

170

Each

6.0000

2

2

D4621-1

Decal

Location

Loc Qty

Loc Code

st113

6

148672

6

7/22/2017

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Shop Packet Print

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Page 3

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Work Order ID: 163226

163226

Parent Item: D4617-041

D4617-041

Parent Item Name: Emergency Escape Ladder

Start Date: 6/26/2017

Required Date: 7/7/2017

Start Qty: 1.00

Required Qty: 1.00

D4621-3

Manufactured No

170

Each

3.0000

1

1

D4621-3

Decal

Location

Loc Qty

Loc Code

st113

3

147701

3

6/20/2017

D4625-1

Manufactured No

170

Each

44.0000

4

4

D4625-1

Tube Cap

Location

Loc Qty

Loc Code

ST114

44

83122

44

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Shop Packet Print

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147369

Page 1

Item ID: D4617-041

Revision ID:

Item Name: Emergency Escape Ladder

Start Date: 6/21/2016 Start Qty: 1.00

Required Date: 6/24/2016 Req'd Qty: 1.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: MLS

Date: JUN 10 2016 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4617	B								

100

100

CNC Bend 1

CNC Delta 100 Bender

Memo

0.00

BEND RAIL AS PER DWG AND TO FIT PROFIL OF WELDING JIG DT9803
(ON LENGTH OF TUBE, 20 FEET MAKES 2 RAILL)

***BENDER SET UP SAME AS BASKET RIB, TOWERS ON NARROW,
RAM AT 2000 PTS FOR BENDING RADIUS***

3 16-7-20

110

110

Large Fab

Large Fab

Weld per dwg A/R 4130 rod Batch: M12705

0.00

Memo

0.32

1- CUT STEPS AS PER DWG AND PREP FOR WELDING

2- CUT RAIL

3- INSTALL PARTS ON WELDING JIG DT9803 AND WELD AS PER DWG

3 16-7-20

Costed

Work Order ID 147369

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147369

Page 2

Item ID: D4617-041

Revision ID:

Item Name: Emergency Escape Ladder

Start Date: 6/21/2016 Start Qty: 1.00

Required Date: 6/24/2016 Req'd Qty: 1.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				(3)	16-07-21	9	DAS 9 JES
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(3)	16-07-21	9	DAS 9 JES
140 *140* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo <i>U/A PD 16-07-26</i>	0.00 0.00							

Work Order ID 147369

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147369

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Item ID: D4617-041 Accept ***N9000040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Emergency Escape Ladder
Start Date: 6/21/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/24/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	Fire Req(Ref:4.3.5.10) per OSI005 4.3 <i>m 127223</i> Memo START TIME: <i>1130</i> OVEN TEMPERATURE: <i>320</i> FINISH TIME: <i>12:00</i>	0.00 0.04				<i>3</i>	<i>0</i>	<i>16-07-26</i>	<i>3 3 3</i>
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
170 *170* Small Fab Small Fab	Memo 1- Assemble clamps, clamps cover and tube caps to ladder as per dwg 2- Install decals as per dwg	0.00 0.13							

See w/o 147369-1

See w/o 163226

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Item ID: D4617-041**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Stop*****NS2*****Item Name:** Emergency Escape Ladder**Start Date:** 6/21/2016 **Start Qty:** 1.00***1*****Cust Item ID:****Required Date:** 6/24/2016 **Req'd Qty:** 1.00***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start*****NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop*****NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.02							

See w/o 147369

Picklist Print

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Wednesday, June 08, 2016 3:06:14 PM

Work Order ID: 147369

147369

Parent Item: D4617-041

D4617-041

Parent Item Name: Emergency Escape Ladder

Start Date: 6/21/2016

Required Date: 6/24/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.04.12 NEW ISSUE DD VER:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NT0.750W.035		Purchased	No			100	f	88.0000	20	21.05263			
M4130NT0 750W 035									**				
4130 RD TUBE .750 X .035W													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT033				88					
				121910				88					
M4130NT0.750W.035		Purchased	No			110	f	88.0000	5.06	5.326316			
M4130NT0 750W 035									**				
4130 RD TUBE .750 X .035W													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT033				88					
				121910				88					
D4617-045		Manufactured	No			170	Each	0.0000	4				
D4617-045									**				
Clamp Assembly													
D4618-041		Manufactured	No			170	Each	17.0000	4				
D4618-041									**				
Clamp Assembly Cover													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				st113				17					
				139782				17					
D4621-1		Manufactured	No			170	Each	0.0000	2				
D4621-1									**				
Decal													
D4621-3		Manufactured	No			170	Each	0.0000	1				
D4621-3									**				
Decal													

JUL 27 2016

Picklist Print

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Wednesday, June 08, 2016 3:06:15 PM

Work Order ID: 147369

147369

Parent Item: D4617-041

D4617-041

Parent Item Name: Emergency Escape Ladder

Start Date: 6/21/2016

Required Date: 6/24/2016

Start Qty: 1.00

Required Qty: 1.00

D4625-1

Manufactured No

170

Each

56.0000

4

4 12

D4625-1

Tube Cap

Location

Loc Qty

Loc Code

ST114

56

83122

56

12

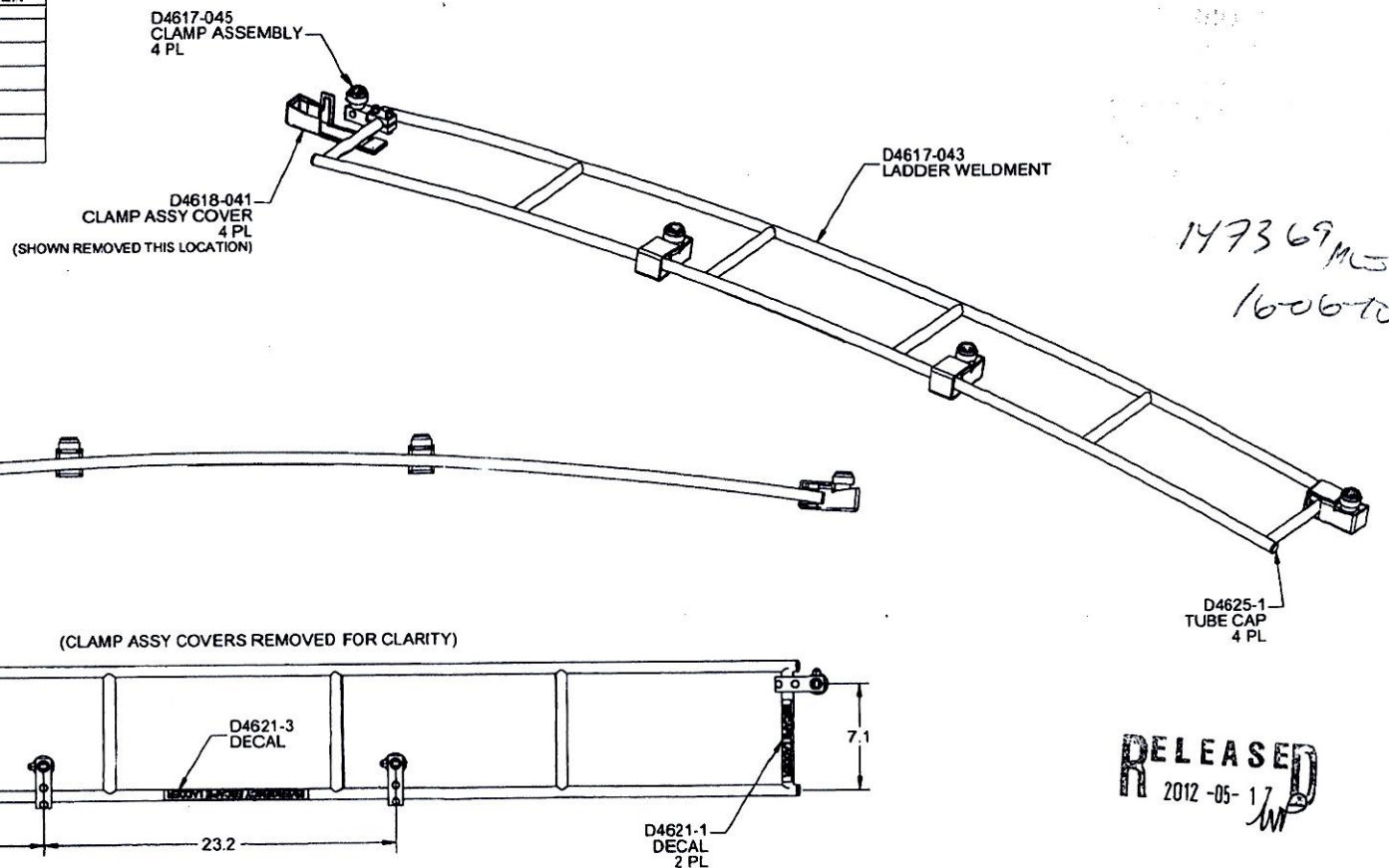
JUL 27 2016

OAS

6

9-89

ITEM	QTY	P/N	DESCRIPTION
	X	D4617-041	EMERGENCY ESCAPE LADDER
1	1	D4617-043	LADDER WELDMENT
2	4	D4617-045	CLAMP ASSY
3	4	D4618-041	CLAMP ASSY COVER
4	2	D4621-1	DECAL
5	1	D4621-3	DECAL
6	4	D4625-1	TUBE CAP



D4617-041 EMERGENCY ESCAPE LADDER

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4617-041" AND BATCH NUMBER PER QSI 044 6.6
 - 7) WEIGHT: 6.48 lbs

B	75.4-75.5 WAS 75.7 (C4-2) WASHER WAS NAS1149C0463R, QTY 3 ON SHT 4. 0.753-0.756 WAS 0.750-0.753 (B4-S)	RP	12.05.01
A	NEW ISSUE	RP	12.04.02
REV.	DESCRIPTION	BY	DATE
DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP	DRAWING NO. D4617 REV. B	
CHECKED	<i>[Signature]</i>	SHEET 1 OF 5	
MFG. APPR.	<i>[Signature]</i>	TITLE EMERGENCY ESCAPE LADDER SCALE NTS	
APPROVED	<i>[Signature]</i>	DATE 12.05.01	
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2012-05-17